



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3698-1

Job Sheet 173711



Part No: D3698-1

Job Qty: 6 ea

Part Name: Support Angle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:A 08-04-25 new issue DD verified by:EC IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec IPP rev:C 08-10-07 revC as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/14/18	0.00	0.00	Start Up Waterjet		SC 18/03/18
100	Waterjet	6 pcs		4/14/18	0.00	1.19	Waterjet1		SC 18/03/18
110	QC	6 pcs		4/14/18	0.00	0.00	QC2 Waterjet-2		SC 18/03/18
120	QC	6 pcs		4/14/18	0.00	0.00	QC8-3		38
130	Brake NC	6 pcs		4/14/18	0.11	3.61	Brake NC 1		DAS 38
140	QC	6 pcs		4/14/18	0.00	0.00	QC5		38
150	HandFinish	6 pcs		4/16/18	0.00	0.73	HandFinish1		D.R. 18/10/18
160	QC	6 pcs		4/16/18	0.00	0.00	QC7-2		OCT 23 2018 68
170	Packaging	6 pcs		4/16/18	0.00	0.00	Packaging3-1	52603	OCT 23 2018 9-89
180	QC21-SA	6 Ea		4/16/18	0.00	0.00	QC21		9-89 21 OCT 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.032	6061-T6 Sheet 0.032"	2.6856 sf (.4476 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.032	3	215	0

5018006

Part Specifications

Specifications could not be found.

Plex 3/6/18 1:07 PM Dart.lajeunesse.marie

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspended ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		DART AEROSPACE Container No: S056292 Part: D3668-1 Job No: 173711 Serial No/ Batch: S056292 Revision: _____ Inspector: _____ Date: 03/29/18 DART AEROSPACE 1270 Aberdeen Street Cambridge, ON K6A 1K7 CANADA TEL: 1 813 692-5200 Email: sales@dartaero.com www.dartaerospace.com			
Description Work Order Deviation							
				Completed By _____ and / Supervisor _____ Approval Verification _____ QA Coordinator Approval _____			

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Fc ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Setback ☐	Folding/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

DART AEROSPACE LTD		Work Order: 173711
Description: Support Angle		Part Number: D3698-1
Inspection Dwg: D3698	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.094	+0.004/-0.001	Ø0,096	1		IPC-01	
Ø0.128	+0.005/-0.001	Ø0,131	1		Tq/R	
1.357	+/-0.010	1,365	1			
0.30	+/-0.030	0,306	1			
0.260	+/-0.010	0,262	1			
1.3	+/-0.100	1,3	1			
4.2	+/-0.100	4,2	1			
6.4	+/-0.100	6,4	1			
9.00	+/-0.030	9,00	1			
11.3	+/-0.100	11,3	1			
13.2	+/-0.100	13,2	1			
15.3	+/-0.100	15,3	1			
17.2	+/-0.100	17,2	1			
19.8	+/-0.100	19,8	1			
22.4	+/-0.100	22,4	1			
47.50	+/-0.030	47,50	1			
5.70	+/-0.030	5,705	1			
1.11	+/-0.030	1,117	1			
0.032	+/-0.010	0,032	1			

Measured by: Se	Audited by: 38	Prototype Approval:	N/A
Date: 18/02/28	Date: APR 06 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	
B	09.05.11	Dimensions updated per Dwg Rev C	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								